

Work Order ID 148706

Wednesday, July 06, 2016 8:43:01 AM

148706

Page 1

Item ID: D3884-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Inboard RH

Start Date: 6/28/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: **DAS 21** Date: **JUL 11 2016** Tooling: _____ Date: _____
QC: **9-89** Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3884	C

100

0.03

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1.27

Program Batch No. **B148706**

Double check by: SL

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

B.A 16/08/09

8

0

**DAS
08
9-89**

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

B.A 16/08/09

8

0

**DAS
08
9-89**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

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Item Name: Saddle, Inboard RH

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				<u>8</u>	<u>0</u>		DAS 32 9-89
120									DAS 45
QC	Memo	0.03							9-89
Quality Control									16-08-11
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.16							
Hand Finishing									

(8)

2016/08/15

BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Page 3

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 Revision ID: Stop ***NS2***
 Item Name: Saddle, Inboard RH
 Start Date: 6/28/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 7/5/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo M134798	0.04							
Powder Coating	***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** ***DO NOT MASK INSIDE FLANGE SURFACE*** START TIME: 11:30am OVEN TEMPERATURE: 320°C FINISH TIME: 12:00pm								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.01							
Quality Control									

DAS
38
9-89

AUG 23 2016

82 f 11/16/08/23

38
9-89
AUG 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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148706

Page 4

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Revision ID: Stop ***NS2***
Item Name: Saddle, Inboard RH
Start Date: 6/28/2016 Start Qty: 8.00 ***8*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST401</u>	0.00					<u>PC</u>		AUG 24 2016
160									
Packaging	Memo	0.01		DAS					
Packaging				6					
				9-89					
170	QC21- Final Inspection - Work Order Release	0.00							AUG 25 2016
170									
QC	Memo	0.13				DAS			
Quality Control						21			
						9-89			

UPF
16-8-24

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																									

Picklist Print

Wednesday, July 06, 2016 8:43:01 AM

Page 1

Work Order ID: 148706

148706

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inboard RH

Start Date: 6/28/2016

Required Date: 7/5/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-017		Manufactured	No				Each	51.0000		8			
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D6101-017

Saddle Billet

B.A 16/08/05

Location

Loc Qty

Loc Code

MAT046

51

142580

1

→ 144956

50

8.0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DART AEROSPACE LTD		Work Order: 148706
Description: Saddle, Inboard, RH		Part Number: D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.647	0.647	0.647	0.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.615	0.615	0.615	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		0.140	0.151	0.151	0.151		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		0.126	0.126	0.126	0.126		
M	0.240	0.260		0.251	0.251	0.251	0.251		
N	0.110	0.140		0.140	0.140	0.140	0.140		
O	0.240	0.260		0.254	0.254	0.253	0.253		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.154	0.154	0.154	0.154		
S	0.720	0.780		0.758	0.758	0.758	0.758		
T	1.220	1.280		1.255	1.255	1.255	1.255		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.495	0.502	0.499	0.499		
Y	0.020	0.040		0.030	0.030	0.030	0.030		
Z	0.313	0.318		0.314	0.314	0.314	0.314		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.217	0.217	0.217	0.217		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by: <u>AS</u>	DAS
Date: <u>16/08/09</u>	UB
	9-89

Audited by: <u>32</u>	DAS
Date: <u>16-08-12</u>	45
	9-89

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	148706
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Inspection Dwg: D3884	Rev. C	Page 1 of 1	

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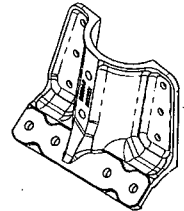
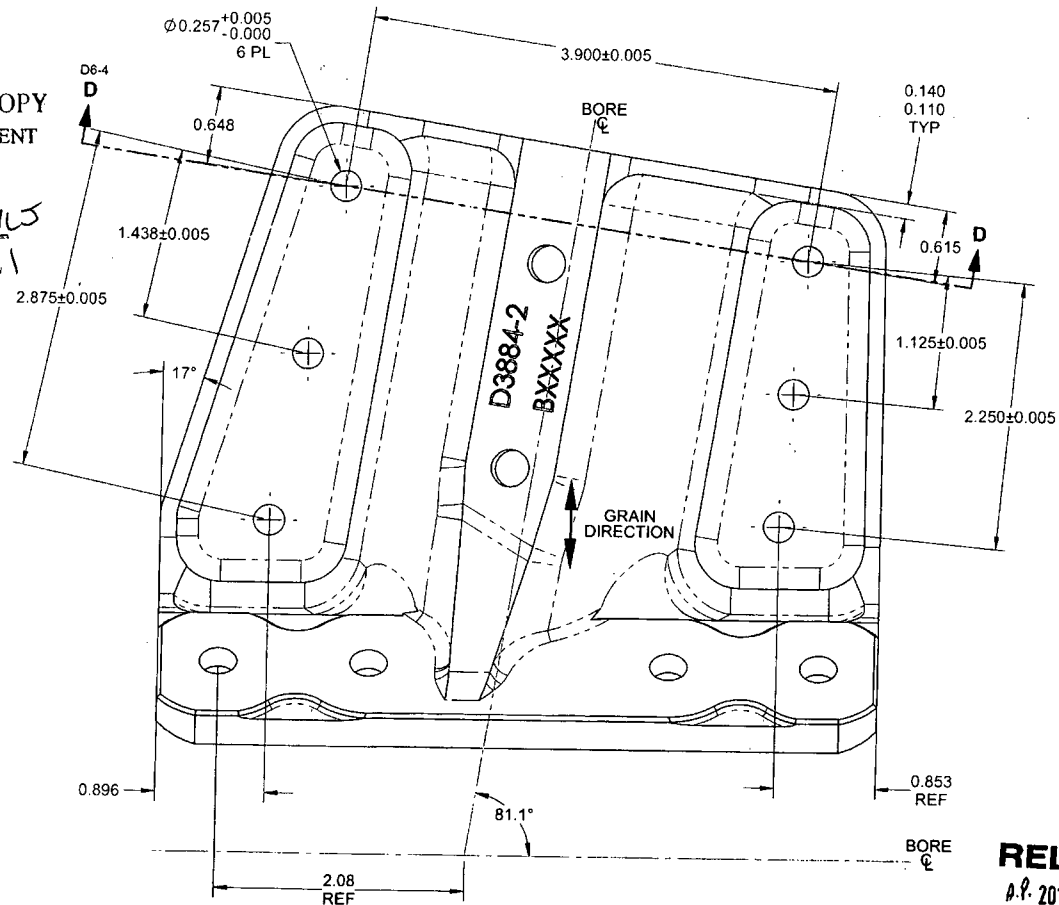
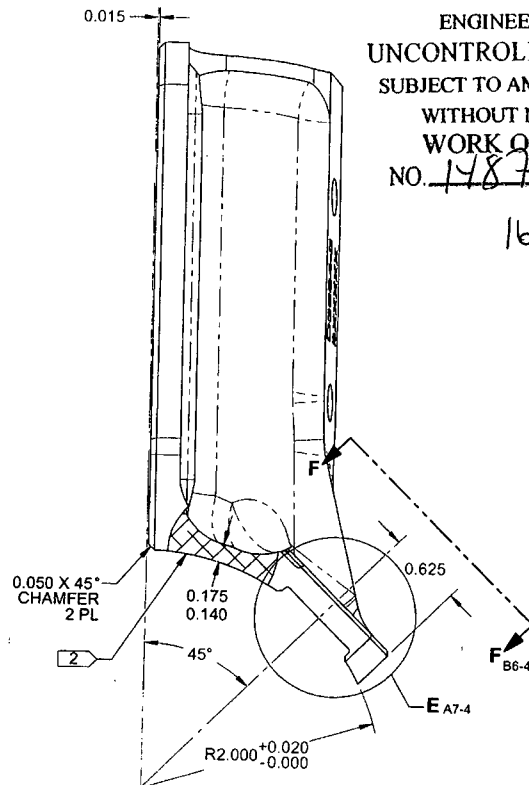
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AF									
Accept/Reject									

Measured by:	A. A	DAS
Date:	16/08/09	08 9-89

Audited by:	45
Date:	16-08-12 9-89

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148706 MJS
1607-11



D3884-2 SADDLE, INBOARD RH

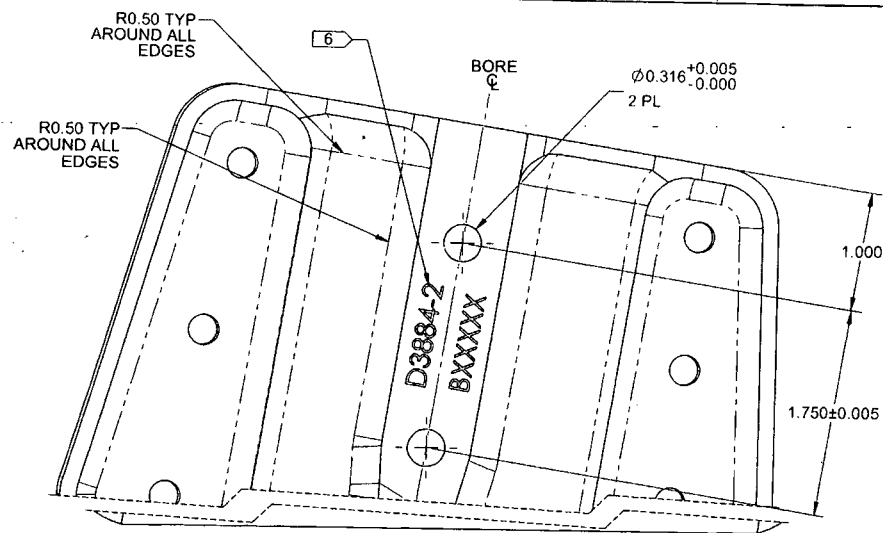
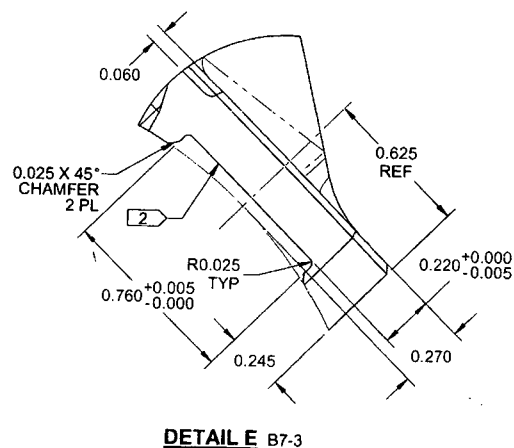
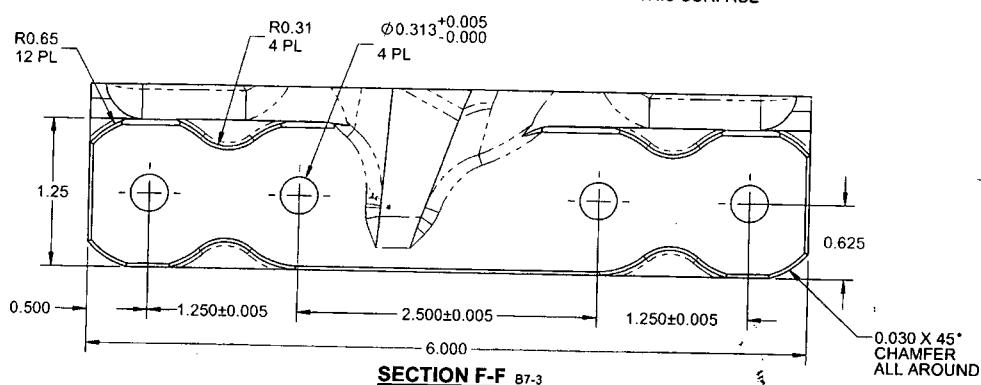
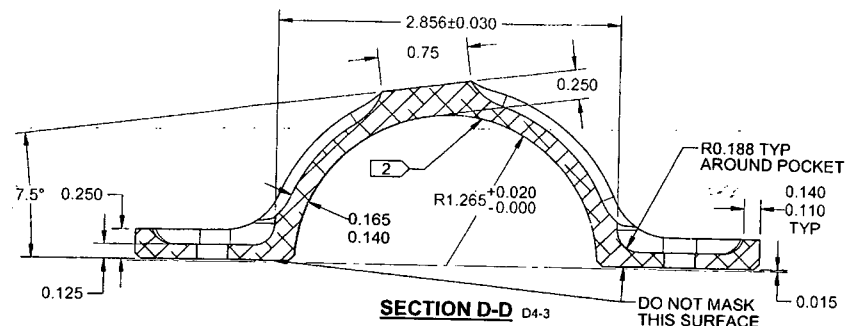
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-2-REVC.SLDPRT"

RELEASE
A.P. 2015 MAY 19

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3884	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	INBOARD SADDLE	NTS
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RELEASED
A.P. 2015 MAY 19

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